

Split

Work Order ID 54730 - 2

December 17, 2009 11:34:45 AM



Page 1

Item ID: D3929-042 *12*

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 17/12/2009 Start Qty: *6.00* *3*



Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: *6.00* *3*



Customer:

Reference:

Approvals: Process Plan: *PJ*

Date: *12/17* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D3929 A

0.00



HB 10-1-4

100

Memo

0.00

Waterjet
FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: *A*

Prog Rev: *B*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



HB 10-1-4

QC

Memo

0.00

Quality Control

Work Order ID 54730

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Page 2

Item ID: D3929-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 17/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00
0.00

S 10/01/09

/01/09

/01/09

/01/09

/01/09

/01/09

/01/09



QC

Memo

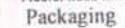
Quality Control

130

Pick Kit

0.00

PD 09.10.05



Packaging

Memo

0.00

PD 10.01.08

Packaging

140



Large Fab

Large Fab

0.00

Memo

0.00

Weld bushings D3907-1 as per dwg D3929

316L rod batch M109215

M109213

PD 10.01.05 (6)

PD 10.01.08 (3)

P10 >

W/O: 54730		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		W/O was split due to extras were made 6 parts on original and 3 parts on this W/O				U	

Part No: D3929-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54730

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Item ID: D3929-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 17/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 25/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

150

QC9- Inspect visual per QSI004- Fusion Welds



QC

Quality Control

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O



QC

Quality Control

0.00

S1010112

0.00

S1010112

(X3)

170

Identify as per dwg & Stock Location: _____



Packaging

Packaging

0.00

Basket cell

0.00

S1010112 (3x)

Work Order ID 54730

December 17, 2009 11:34:45 AM



Page 4

Item ID: D3929-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 17/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/14 JG

MF 10-1-13

Picklist Print

Page 1

December 17, 2009 11:34:49 AM

Work Order ID: 54730



Parent Item: D3929-042



Parent Item Name: Gusset Assembly

Start Date: 17/12/2009

Required Date: 23/12/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304S11GA

Purchased

No

100

sf

107.0791

2.8421

4.3

WB 10-1-4

304/316 0.125 Sheet

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

MAT

107.0791

112663

107.0791

112663

D3907-1

Manufactured

No

130

Each

57.0000

12.0000



Bushing

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

17

PD 10.01.05

53673

17

Main Warehouse

WA

40

PD 10.01.05

54042

40

6 PD 10.01.08

DART AEROSPACE LTD	Work Order:	54730
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-4	Date:	10/01/04	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	09.05.27	New Issue	P/O D3929-041/-042	KJ 	

8

7

6

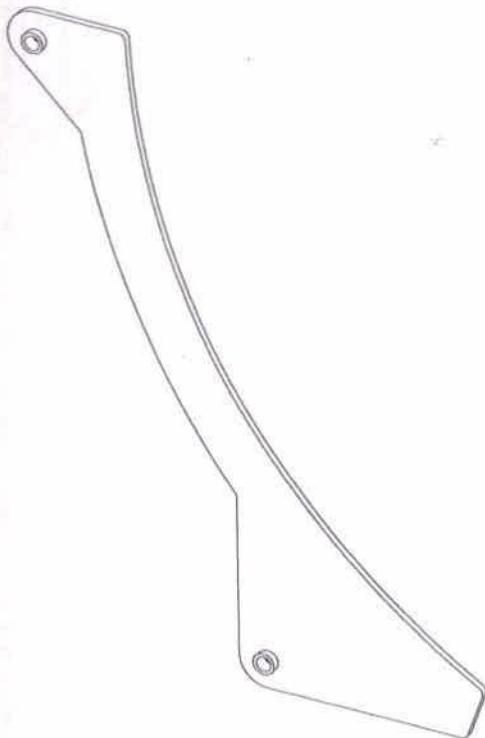
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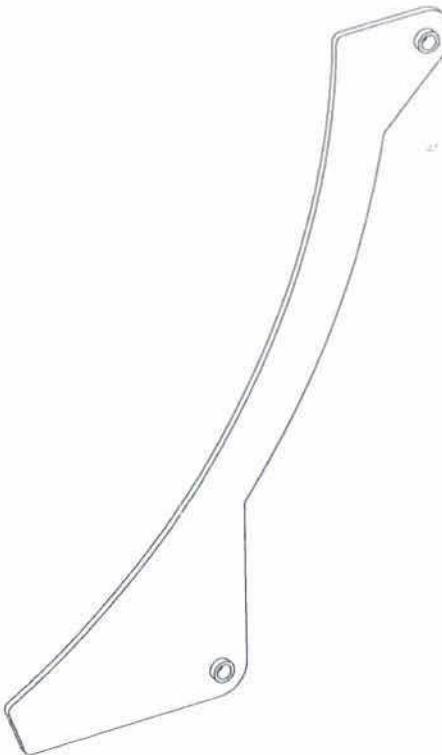
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1



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

D

C

B

A

NOTES:

- MATERIAL: N/A
- FINISH: N/A
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- WEIGHT: 0.73 lbs EACH
- WELDING: PER DART QSI 004

8

7

6

5

4

3

2

1

RELEASED
09/04/22 MJD

W0 54730

A	NEW ISSUE	MB:	09.04.03
REV	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	
DATE	09.04.03	NTS	

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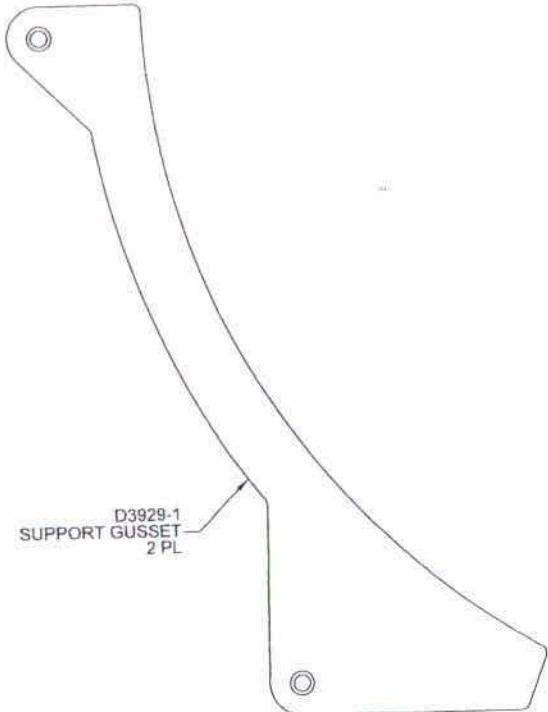
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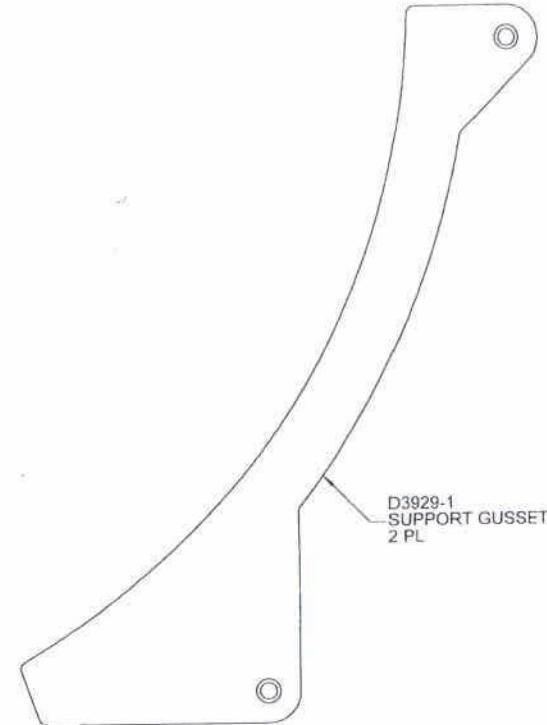
3

2

1



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/2011

W/O 54730

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. A
MFG. APPR.		SHEET 2 OF 3
APPROVED		SCALE
DE APPR.		NTS
DATE	09.04.03	

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5

4

3

2

1

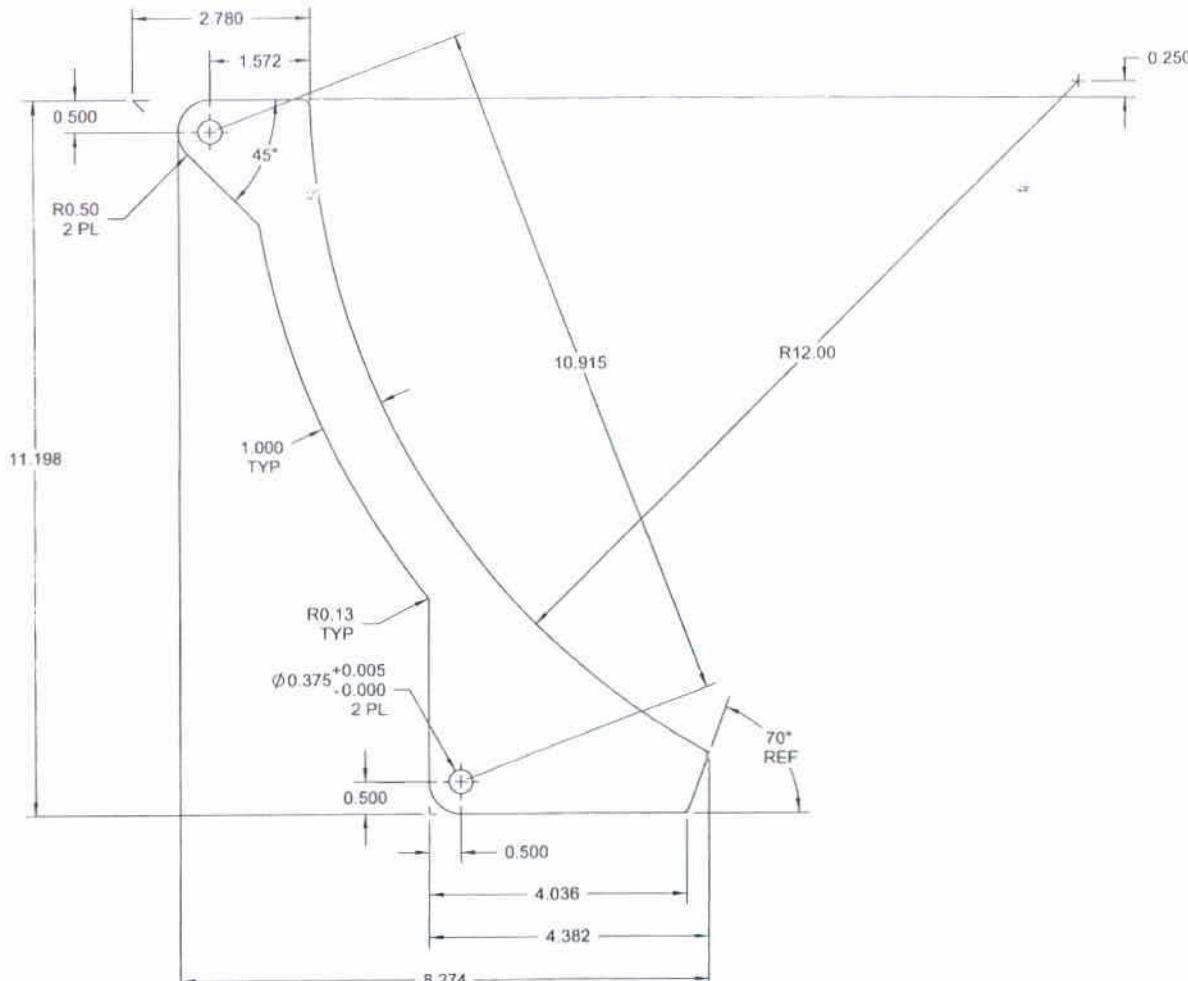
A

D

B

C

B



D3929-1 SUPPORT GUSSET

RELEASED
01054730

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524

11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.72 lbs

DESIGN	<u> </u>	DART AEROSPACE LTD
DRAWN	<u> </u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<u> </u>	DRAWING NO: REV. A
MFG. APPR.	<u> </u>	D3929 SHEET 3 OF 3
APPROVED	<u> </u>	TITLE
DE APPR.	<u> </u>	SCALE
DATE	09.04.03	NTS

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